

Date: Wednesday, 29/10/2008 7:59:58 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 43053

Part Number: PB674300163

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PB6743001133

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

batch: 23994

ST

MF 08-11-14

13.0

PB6743001137

Locking Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Locking Sleeve

batch: 40023

ST

MF 08-11-14

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble by drilling thru both -157 and -133 as per dwg

2- install spring slotted pin as per dwg

SMD 08-11-17

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soslu/18 (10)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P - 8 Jul 19 (1)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



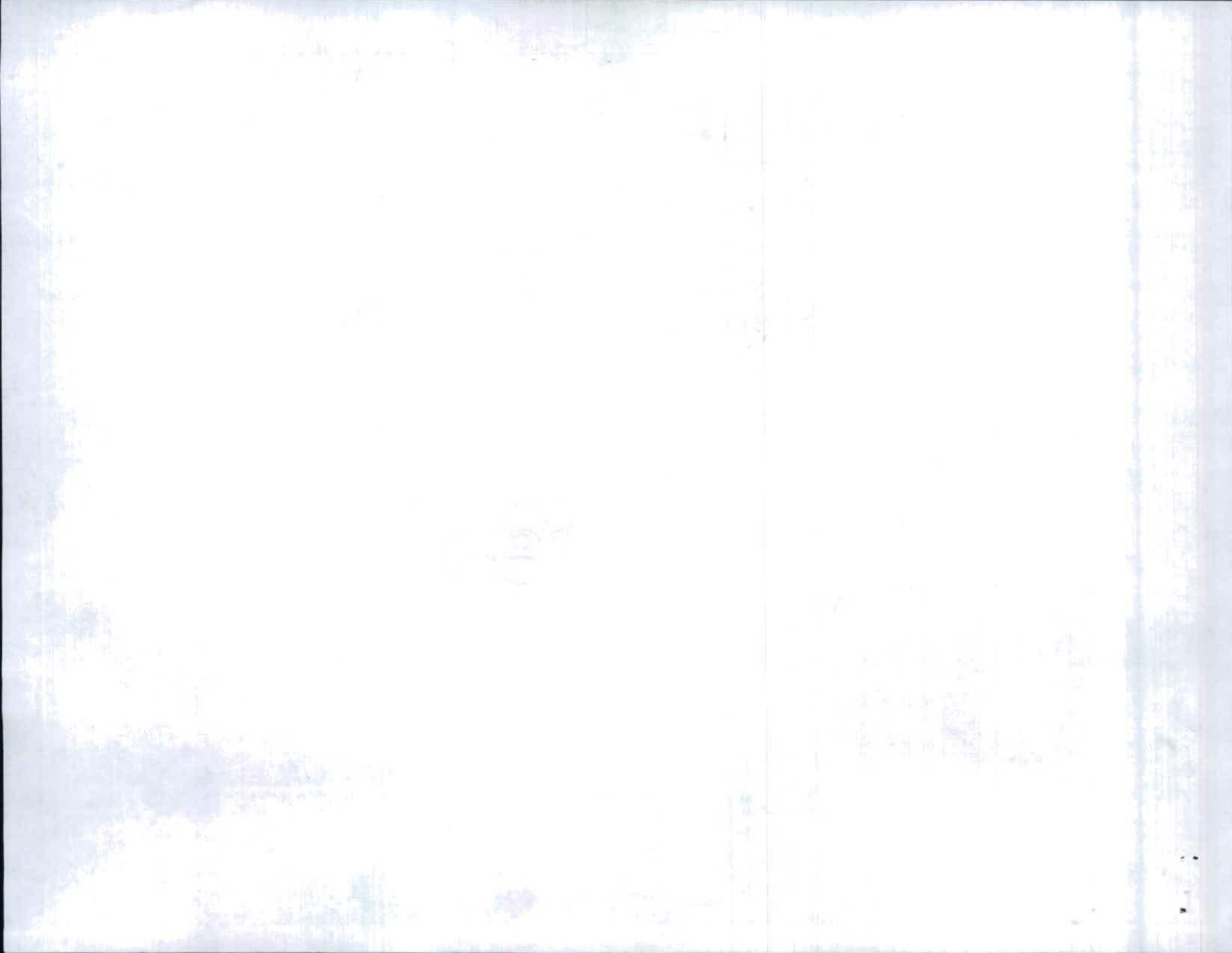
Comment: FINAL INSPECTION/W/O RELEASE

08/11/2019

Job Completion



MF 08-11-19



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Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg

(+1)

Pl 08-11-13

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/11/14 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/14 (2)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 102316

(IX)

****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat****

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30
220 °F
12:00

M-L 08/11/14

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 08-11-17

11.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SPRING SLOTTED PIN

batch: m17850

MF 08-11-14

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Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT T-HANDLE ASSY
Job Number	: 43053-2	Part Number	: PB674300163
Estimate Number	: 13529	Drawing Number	: B6743001 P.15
P.O. Number	:	Project Number	: N/A
This Issue	: 29/10/2008 S.O. No. :	Drawing Revision	: B1
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : LARGE FAB ASSY	Due Date	: 05/11/2008
Previous Run	: 41384	Qty:	1/2 mf 08-11-12
Written By	:	Um:	Each
Checked & Approved By	: mf 08-10-29		
Comment	: Est Rev:A 08-07-29 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001131	Tube End Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube End Cap

batch: 41480 ✓

mf 08-11-11

2.0	PB6743001129	Tube Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube Handle

batch: 40019 ✓

mf 08-11-11

3.0	PB6743001127	Handle Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Arm

batch: 41479 B40018 x 1 *

mf 08-11-11

4.0	PB6743001157	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube

batch: 40026 ✓

mf 08-11-11

5.0	CR321342	Cherry Rivet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivet

batch: M102569 ✓

mf 08-11-11